

**Work Order ID 99205**

Monday, April 01, 2013 3:49:33 PM

**\*99205\***

Ship April 4th Page 1

Item ID: DSI 9645-011

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Stub Cover Installation

Start Date: 4/1/2013 Start Qty: 20.00

**\*20\***

Cust Item ID:

Required Date: 4/4/2013 Req'd Qty: 20.00

**\*20\***

Customer:

Reference:

Approvals: Process Plan: *WVF*

Date: 13-4-01

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursTool ID Tool # Plan  
Code Accept Reject Reject Insp.  
Qty Qty Number Stamp

Draw Nbr

Revision Nbr

DSI 9645

A

100

**\*100\***

DC

Document Control

DOCUMENT CONTROL

Memo

Photocopy bluefile &amp; type labels per PPP DSI9645-011 CHG001

0.00

0.00

110

**\*110\***

Packaging

Packaging

Pick Kit

Memo

0.00

0.00

120

**\*120\***

QC

Quality Control

QC4- 100% Inspect kits for completeness

Memo

0.00

0.00

20

*13/4/13 (210)*

20

*13/4/13*

NCR: Yes / No

**WORK ORDER NON-CONFORMANCE / UPDATE**

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order: _____  Part No. _____  NCR No. _____				<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		<b>AGAINST DEPARTMENT/PROCESS</b>  <div style="display: flex; justify-content: space-between;"> <div>           Skid-tube <input type="checkbox"/>            Machining <input type="checkbox"/>            Thermoforming <input type="checkbox"/>            Large Fab <input type="checkbox"/> </div> <div>           Crosstube <input type="checkbox"/>            Small Fab <input type="checkbox"/>            Finishing <input type="checkbox"/>            Composite <input type="checkbox"/> </div> <div>           Water Jet <input type="checkbox"/>            Prod. Eng. Coord. <input type="checkbox"/>            Rec/Store/Packaging <input type="checkbox"/>            Supplier <input type="checkbox"/> </div> <div>           Engineering <input type="checkbox"/>            Quality <input type="checkbox"/>            Other <input type="checkbox"/> </div> </div>						
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector			
Doc/Data <input type="checkbox"/>												
Equip/Tooling <input type="checkbox"/>												
Operator <input type="checkbox"/>												
Material <input type="checkbox"/>												
Setup <input type="checkbox"/>												
Other <input type="checkbox"/>												
Process <input type="checkbox"/>												
Supplier <input type="checkbox"/>												
Training <input type="checkbox"/>												
Unapproved <input type="checkbox"/>												
<b>FAULT CATEGORY</b>												
<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube			<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio			<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions			<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge  <hr/> <hr/> <hr/>		<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled  <input type="checkbox"/> Other	

**Work Order ID 99205**

Monday, April 01, 2013 3:49:33 PM

**\*99205\***

Page 2

Item ID: DSI 9645-011

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Stub Cover Installation

Start Date: 4/1/2013 Start Qty: 20.00

**\*20\***

Cust Item ID:

Required Date: 4/4/2013 Req'd Qty: 20.00

**\*20\***

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

0.00

**\*130\***

Packaging

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP DSI9645-011

Location: \_\_\_\_\_

20x 8 13-4-4

140

QC21- Final Inspection - Work Order Release

0.00

**\*140\***

QC

Memo

0.00

Quality Control

MCJ 1304-04

13-01-4

NCR: Yes / No

**WORK ORDER NON-CONFORMANCE / UPDATE**

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order: _____  Part No. _____  NCR No. _____	<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>  <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data									
Equip/Tooling									
Operator									
Material									
Setup									
Other									
Process									
Supplier									
Training									
Unapproved									

**FAULT CATEGORY**

<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions	<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge	<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled  <input type="checkbox"/> Other
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# Picklist Print

Monday, April 01, 2013 3:49:33 PM

Page 1

Work Order ID: 99205

Parent Item: DSI 9645-011

Parent Item Name: Stub Cover Installation

Start Date: 4/1/2013

Required Date: 4/4/2013

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP REV:A 13.03.13 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
<b>D4778-1</b> Stub Cover	<i>Smb 20x</i>	Manufactured	No			110	Each	0.0000	<i>1</i>	20	<i>98874</i>		
<b>D4779-041</b> Aft Cover Mounting Bracket Assembly		Manufactured	No			110	Each	1.0000	<i>1</i>	20	<i>99256</i>		
						<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>				
						ST		1					
						98547		1					
<b>D4780-041</b> Fwd Cover Mounting Bracket Assembly		Manufactured	No			110	Each	1.0000	<i>1</i>	20	<i>9859714</i>		
						<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>				
						ST		1					
						98548		1					
<b>MS35207-263</b> Screw		Purchased	No			110	Each	941.0000	<i>8</i>	160	<i>14999207</i>		
						<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>				
						ST289		941					
						104746		630					
						13276		311					
<b>NAS1149D0363J</b> Washer		Purchased	No			110	Each	4,859.0000	<i>8</i>	160	<i>13276</i>		
						<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>				
						FP001		1					
						123248		1					
						ST294		4858					
						122378		75					
						124392		4783					

*124392*

*1304-02*

NCR: Yes / No

**WORK ORDER NON-CONFORMANCE / UPDATE**

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order: _____  Part No. _____  NCR No. _____				<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		<b>AGAINST DEPARTMENT/PROCESS</b>  <div style="display: flex; justify-content: space-between;"> <div>           Skid-tube <input type="checkbox"/>            Machining <input type="checkbox"/>            Thermoforming <input type="checkbox"/>            Large Fab <input type="checkbox"/> </div> <div>           Crosstube <input type="checkbox"/>            Small Fab <input type="checkbox"/>            Finishing <input type="checkbox"/>            Composite <input type="checkbox"/> </div> <div>           Water Jet <input type="checkbox"/>            Prod. Eng. Coord. <input type="checkbox"/>            Rec/Store/Packaging <input type="checkbox"/>            Supplier <input type="checkbox"/> </div> <div>           Engineering <input type="checkbox"/>            Quality <input type="checkbox"/>            Other <input type="checkbox"/> </div> </div>						
<b>Root Cause</b>	<b>Date</b>	<b>Step</b>	<b>Qty</b>	<b>Description of work order update or Non-conformance</b>	<b>Initial Chief Eng</b>	<b>Action Description</b>	<b>Sign &amp; Date</b>	<b>Verification</b>	<b>QC Inspector</b>			
Doc/Data <input type="checkbox"/>												
Equip/Tooling <input type="checkbox"/>												
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# Work Order ID 99205

Monday, April 01, 2013 3:49:33 PM

\*99205\*

Ship April 4th Page 1

Item ID: DSI 9645-011

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Stub Cover Installation

Start Date: 4/1/2013 Start Qty: 20.00

\*20\*

Required Date: 4/4/2013 Req'd Qty: 20.00

\*20\*

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: *mf*

Date: 13-4-01

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

Draw Nbr

Revision Nbr

DSI 9645

A

100

\*100\*

DC

Document Control

DOCUMENT CONTROL

Memo

Photocopy bluefile & type labels per PPP DSI9645-011 CHG001

0.00

0.00

MLS 13-04-02

*(Signature)*

110

Pick Kit

0.00

\*110\*

Packaging

Memo

0.00

Packaging

120

QC4- 100% Inspect kits for completeness

0.00

\*120\*

QC

Memo

0.00

Quality Control

*Refer only SMD*

# DART SERVICE INSTRUCTION

## TO AMEND INSTALLATION INSTRUCTIONS IIN-D350-616 Rev C

REF CANADIAN STC: SH96-10  
REF FAA STC: SR00405NY  
REF DANISH STC: 27/96 AND 28/96  
REF UK CAA STC: 28097  
REF DGAC FRANCE STC: 84-SI0995 AND 168-SI0996  
REF BRAZILIAN STC: 2013S02-03

### 1.0 PURPOSE:

THE PURPOSE OF THIS SERVICE INSTRUCTION IS TO OUTLINE THE PROCEDURE FOR REPLACING THE D3494-1 STUB COVER WITH THE D4778-1 STUB COVER BY INSTALLING THE DSI 9645-011 KIT. THE D4778-1 COVER IS DESIGNED TO ELIMINATE THE POTENTIAL FOR INTERFERENCE WITH THE PEDAL STUBS ON SOME AIRCRAFT AND WILL BE INCLUDED IN D350-616-011 KITS AT CHG 005 AND LATER.

### 2.0 INSTALLATION:

- 2.1 FOR EASE OF INSTALLATION, REMOVE THE D3179-041 LITTER TIE DOWN.
- 2.2 REMOVE THE D3494-1 STUB COVER AND HARDWARE, IF REQUIRED.
- 2.3 PICKING UP ON THE SAME MOUNTING HOLES, INSTALL THE FWD (D4780-041) AND AFT (D4779-041) MOUNTING BRACKETS USING MS35207-263 SCREWS (QTY 4) AND NAS1149D0363J WASHERS (QTY 4).
- 2.4 SLIDE THE D4778-1 STUB COVER OVER THE COVER BRACKETS AND FASTEN WITH MS35207-263 SCREWS (QTY 4) AND NAS1149D0363J WASHERS (QTY 4).
- 2.5 RE-INSTALL THE D3179-041 LITTER TIE DOWN.

NOTE: IT IS PERMISSABLE TO TRIM THE COVER EDGE, AS REQUIRED, FOR CLEARANCE OVER DECK PLATES

### 3.0 PARTS LIST

QTY -011	P/N	DESCRIPTION
X	DSI 9645-011	STUB COVER INSTALLATION KIT
1	D4778-1	STUB COVER
1	D4779-041	AFT COVER MOUNTING BRACKET ASSY
1	D4780-041	FWD COVER MOUNTING BRACKET ASSY
8	MS35207-263	SCREW
8	NAS1149D0363J	WASHER

### 4.0 WEIGHT AND BALANCE

INSTALLATION OF THE DSI 9645-011 STUB COVER INSTALLATION HAS NEGLIGIBLE EFFECT ON WEIGHT AND BALANCE.

CANADA  
DEPARTMENT OF TRANSPORT  
AIRCRAFT CERTIFICATION  
BRANCH  
DAO # 01-O-01

APPROVED

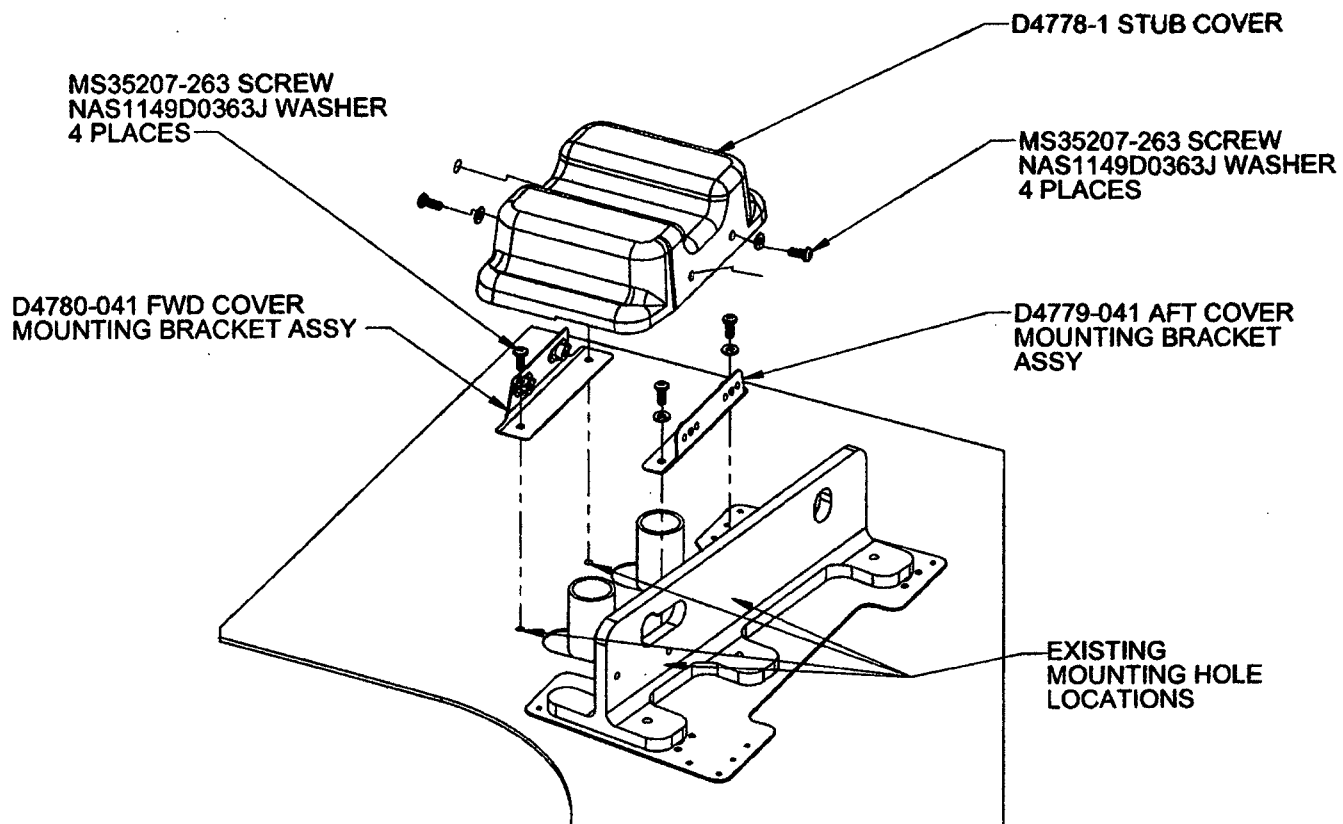
BY:

D. SHEPHERD (DE # 02)

DATE: 13.03.06  
CERT. NO.: SH96-10  
ISSUE NO.: # 2

A	NEW ISSUE	DB	13.03.06
REV.	DESCRIPTION		BY DATE
DESIGN	DB	DART AEROSPACE LTD	
DRAWN	DB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	A.P.	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9645	SHEET 1 OF 2
APPROVED	MP	TITLE	SCALE
DE APPR.		STUB COVER INSTALLATION	NTS
DATE	13.03.06	COPYRIGHT © 2013 BY DART AEROSPACE LTD	
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**FIGURE 1: PEDAL COVER INSTALLATION**

DESIGN	DB	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	DB		
CHECKED	A.P.	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9645	SHEET 2 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	STUB COVER INSTALLATION	NTS
DATE	13.03.06	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	